

Work Order ID 114293

March-04-14 3:00:41 PM

114293

Page 1

Item ID: D3391-025

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Aft Tube Assembly

Stop

NS2

Start Date: 04/03/2014 Start Qty: 1.00

1

Cust Item ID:

Required Date: 04/03/2014 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

NP

Date: 140305

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3391	I

100		0.00							
-----	--	------	--	--	--	--	--	--	--

100	MORI SEIKI CNC LATHE LARGE								
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Mori Seiki	Memo	0.00							
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Mori Seiki CNC Lathe Large	Turn as per Folio FA599	Rev: AA	& Dwg D3391 Rev:						
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> Remove steady Rest slabs

110	QC2- Inspect parts off machine FAI/FAIB	0.00							
-----	---	------	--	--	--	--	--	--	--

110	Memo	0.00							
--------------	------	------	--	--	--	--	--	--	--

QC									
----	--	--	--	--	--	--	--	--	--

Quality Control									
-----------------	--	--	--	--	--	--	--	--	--

112	QC5- Inspect part completeness to step on W/O	0.00							
-----	---	------	--	--	--	--	--	--	--

112	Memo	0.00							
--------------	------	------	--	--	--	--	--	--	--

QC									
----	--	--	--	--	--	--	--	--	--

Quality Control									
-----------------	--	--	--	--	--	--	--	--	--

SIN
14/3/12

KC
14/03/08

man.6
14/03/09

DQA:

Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date: _____

Work Order update only

Work Order: _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> Water Jet <input type="checkbox"/> Prod. Eng. Coor. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/>
Part No. _____		Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>
NCR No. _____		

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled	

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114293

Page 2

Item ID: D3391-025

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Aft Tube Assembly

Stop

NS2

Start Date: 04/03/2014 Start Qty: 1.00

1

Cust Item ID:

Required Date: 04/03/2014 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

120

HAAS 1

HAAS CNC VERTICAL MACHINING #1

0.00

on 14/03/16

1

4

HAAS CNC vertical machine #1

Memo

0.00

1-Machine as per Folio FA 599 Rev: A & Dwg D3391 Rev: I
2-Deburr

130

130

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

on 14/03/16

1

0

140

140

QC

Quality Control

QC8- Inspect parts - second check

0.00

B-a 14/03/18

1

0

Memo

0.00

INSPECT INSIDE BORE

DAS
08
9-89

DQA: _____

Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____

Date: _____

Work Order update only

Work Order: _____	DISPOSITION	AGAINST DEPARTMENT/PROCESS					
Part No. _____ NCR No. _____	Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/>	Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/>	Water Jet <input type="checkbox"/> Prod. Eng. Coor. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/>	Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>		

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
---	--	---	--	--

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114293

Page 3

Item ID: D3391-025

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Aft Tube Assembly

Stop

NS2

Start Date: 04/03/2014 Start Qty: 1.00

1

Cust Item ID:

Required Date: 04/03/2014 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

150

Skidtubes

Skidtubes

0.00

DC 14 / 03 / 19

Skidtubes

Memo

0.00

1-Drill (PILOT HOLE) aft cap holes per Dwg D3391 using DT8803

160

160

CNC Bend 1

CNC Delta 100 Bender

BENDING MACHINE - SKIDTUBES

0.00

Memo

0.00

Form as per Dwg D3391 Using Bend Prog 3391025

DC 14 / 03 / 25

170

170

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

H 4, 1"

DAS
03
9-09

D 14-3-25

DQA: _____ Date: _____

QA Closed: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

Work Order update only

Work Order: _____			DISPOSITION		AGAINST DEPARTMENT/PROCESS					
			Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>			
			Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>			
			Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>			
			Suspected Unapproved <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>				
Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector	
Design										
Doc/Data										
Equip/Tooling										
Handling/Pre										
Material										
Operator										
Offset/Setup										
Process										
Supplier										
Training										
Transport										
Unapproved										

FAULT CATEGORY

Landing Gear	General			
Bending	Bend			Outside Dimensions
Centre Not Concentric	BOM/Route			Over/Under tolerance
Cracks	Broken/Damage/Defect			Part Incorrect
Crimp/Kink/Ripple/Wave	Burrs			Part Lost/Missing
Cuffs	Contamination			Part Moved
Crushing	Countersink			Positioned Wrong
Heat Treat	Cut Too Short			Power Loss/Surge
Inspection Strip in Tube	Drawing			Other
Marks/Chatter	Drill Holes			
Turning Sequence	Finish			
Wave/Twist in Tube	Fit/Function			

Item ID: D3391-025

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Aft Tube Assembly

Stop

NS2

Start Date: 04/03/2014 Start Qty: 1.00

1

Cust Item ID:

Required Date: 04/03/2014 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

180

Skidtubes

Skidtubes

0.00

Skidtubes

Memo

0.00

1-Open Aft cap pilot hole to .208" as per Dwg D3391

2-Drill float bag holes using DT8809 as per Dwg D3391(Holes marked "A" Only)

3-Drill wearplate holes as per Dwg D3391 using DT8878(Mid Tube) & DT8217
Wearplate Jig .

*****Do Not Open To Finished Size*****

4-Drill Wearshoe holes as per DWG D3391 using DT8939 locating from 2
previously drilled aft wearplate holes.

5-Open wearplate holes to 0.297" and c'bore as per dwg D3391

6-Open up all float bag holes to 0.328" and c'sink as per Dwg D3391

7-Deburr

8- Scribe batch # on fwd end

- DC 14/04/02

DP 14-4-3

DGL 14-4-3

DQA: _____ Date: _____

Date:



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only

Work Order: _____			DISPOSITION		AGAINST DEPARTMENT/PROCESS					
Part No. _____			Rework Scrap Use-as-is Suspected Unapproved	Skid-tube Machining Thermoforming Large Fab	Crosstube Small Fab Finishing Composite	Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier	Engineering Quality Other			
NCR No. _____										
Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector	
Design										
Doc/Data										
Equip/Tooling										
Handling/Pre										
Material										
Operator										
Offset/Setup										
Process										
Supplier										
Training										
Transport										
Unapproved										
FAULT CATEGORY										
Landing Gear			General							
Bending	Bend		Folio/Program		Outside Dimensions		Pressure/Forced			
Centre Not Concentric	BOM/Route		Grain		Over/Under tolerance		Set-up			
Cracks	Broken/Damage/Defect		Hardware		Part Incorrect		Temperature/Cure			
Crimp/Kink/Ripple/Wave	Burrs		Inspection Incomplete/Unqualified		Part Lost/Missing		Weld			
Cuffs	Contamination		Instructions Incomplete/Unclear		Part Moved		Wrong Stock Pulled			
Crushing	Countersink		Misaligned/off center		Positioned Wrong					
Heat Treat	Cut Too Short		Mislabeled		Power Loss/Surge					
Inspection Strip in Tube	Drawing		Misread							
Marks/Chatter	Drill Holes		Off-set							
Turning Sequence	Finish		Out of Calibration							
Wave/Twist in Tube	Fit/Function		Out of Sequence							

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Page 5

Item ID: D3391-025

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Aft Tube Assembly

Stop

NS2

Start Date: 04/03/2014 Start Qty: 1.00

1

Cust Item ID:

Required Date: 04/03/2014 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 *190* QC	QC5- Inspect part completeness to step on W/O	0.00						① 14-04-01	DAS 9 9-89
Quality Control	Memo	0.00							
200 *200* HandFinish	Chemical Conversion Coat per QSI005 4.1	0.00						1 7/14-47	
Hand Finishing	Memo	0.00							
210 *210* QC	QC7-Inspect Chemical Conversion Coat	0.00						1 6 10/14/04/09	
Quality Control	Memo	0.00							

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only

Work Order: _____			DISPOSITION		AGAINST DEPARTMENT/PROCESS				
Part No. _____	Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>				
NCR No. _____	Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>				
	Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>				
	Suspected Unapproved <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>					
Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									
FAULT CATEGORY									
Landing Gear			General						
Bending	Bend <input type="checkbox"/>	Folio/Program <input type="checkbox"/>	Outside Dimensions <input type="checkbox"/>	Pressure/Forced <input type="checkbox"/>					
Centre Not Concentric	BOM/Route <input type="checkbox"/>	Grain <input type="checkbox"/>	Over/Under tolerance <input type="checkbox"/>	Set-up <input type="checkbox"/>					
Cracks	Broken/Damage/Defect <input type="checkbox"/>	Hardware <input type="checkbox"/>	Part Incorrect <input type="checkbox"/>	Temperature/Cure <input type="checkbox"/>					
Crimp/Kink/Ripple/Wave	Burrs <input type="checkbox"/>	Inspection Incomplete/Unqualified <input type="checkbox"/>	Part Lost/Missing <input type="checkbox"/>	Weld <input type="checkbox"/>					
Cuffs	Contamination <input type="checkbox"/>	Instructions Incomplete/Unclear <input type="checkbox"/>	Part Moved <input type="checkbox"/>	Wrong Stock Pulled <input type="checkbox"/>					
Crushing	Countersink <input type="checkbox"/>	Misaligned/off center <input type="checkbox"/>	Positioned Wrong <input type="checkbox"/>						
Heat Treat	Cut Too Short <input type="checkbox"/>	Mislabeled <input type="checkbox"/>	Power Loss/Surge <input type="checkbox"/>	Other <input type="checkbox"/>					
Inspection Strip in Tube	Drawing <input type="checkbox"/>	Misread <input type="checkbox"/>							
Marks/Chatter	Drill Holes <input type="checkbox"/>	Off-set <input type="checkbox"/>							
Turning Sequence	Finish <input type="checkbox"/>	Out of Calibration <input type="checkbox"/>							
Wave/Twist in Tube	Fit/Function <input type="checkbox"/>	Out of Sequence <input type="checkbox"/>							

Work Order ID 114293

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114293

Page 6

Item ID: D3391-025 Accept: *N900040100* Setup: *NS1*
Revision ID:
Item Name: Aft Tube Assembly Stop: *NS2*
Start Date: 04/03/2014 Start Qty: 1.00 *1* Cust Item ID:
Required Date: 04/03/2014 Req'd Qty: 1.00 *1* Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NB2*

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only

Work Order: _____	DISPOSITION	AGAINST DEPARTMENT/PROCESS							
Part No. _____	Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>				
NCR No. _____	Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>				
	Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>				
	Suspected Unapproved <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>					

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear	General		
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Folio/Program	<input type="checkbox"/> Outside Dimensions
<input type="checkbox"/> Centre Not Concentric	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Grain	<input type="checkbox"/> Pressure/Forced
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damage/Defect	<input type="checkbox"/> Hardware	<input type="checkbox"/> Set-up
<input type="checkbox"/> Crimp/Kink/Ripple/Wave	<input type="checkbox"/> Burrs	<input type="checkbox"/> Inspection Incomplete/Unqualified	<input type="checkbox"/> Temperature/Cure
<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Instructions Incomplete/Unclear	<input type="checkbox"/> Weld
<input type="checkbox"/> Crushing	<input type="checkbox"/> Countersink	<input type="checkbox"/> Misaligned/off center	<input type="checkbox"/> Wrong Stock Pulled
<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Mislabeled	<input type="checkbox"/> Other
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Drawing	<input type="checkbox"/> Misread	
<input type="checkbox"/> Marks/Chatter	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Off-set	
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Calibration	
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Fit/Function	<input type="checkbox"/> Out of Sequence	

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114293

Page 7

Item ID: D3391-025

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Aft Tube Assembly

Stop

NS2

Start Date: 04/03/2014 Start Qty: 1.00

1

Cust Item ID:

Required Date: 04/03/2014 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

235

Pressure Wash per QSI005 4.3

0.00

235

HandFinish

Memo

0.00

1 7/6/14-415

Hand Finishing

AND REALODINE AS PER PAR09-043

240

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

240

Powdercoat

Powder Coating

Memo

0.00

START TIME: 2:35

OVEN TEMPERATURE: 320°

FINISH TIME: 3:20

1 6/14-99 DAS 34 9.89

250

QC3- Inspect Part Finish

0.00

250

QC

Quality Control

Memo

0.00

1 6/14-105 DAS 15 9.89

DQA: _____ Date: _____

Date:



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only

Work Order: _____ Part No. _____ NCR No. _____			DISPOSITION		AGAINST DEPARTMENT/PROCESS						
			Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/>	Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/>	Water Jet <input type="checkbox"/> Prod. Eng. Coor. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/>	Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>				
Root Cause	Date	Step	Qty	Description of work order update or non-conformance		Initial Chief Eng	Action Description		Sign & Date	Verification	QC Inspector
Design											
Doc/Data											
Equip/Tooling											
Handling/Pre											
Material											
Operator											
Offset/Setup											
Process											
Supplier											
Training											
Transport											
Unapproved											
FAULT CATEGORY											
Landing Gear			General								
Bending Centre Not Concentric Cracks Crimp/Kink/Ripple/Wave Cuffs Crushing Heat Treat Inspection Strip in Tube Marks/Chatter Turning Sequence Wave/Twist in Tube			Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function <input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/>								
			Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other <input type="checkbox"/>								

Work Order ID 114293

March-04-14 3:00:41 PM

114293

Page 8

Item ID: D3391-025 Accept ***N900040100*** Setup Start ***NS1***

Revision ID:

Item Name: Aft Tube Assembly Stop ***NS2***Start Date: 04/03/2014 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 04/03/2014 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
260 *260* HandFinish	HandFinishing	0.00							
Hand Finishing	Memo	0.00							
	1-Install inserts as per Dwg D3391								
	2-Install Aft Cap as per Dwg D3391								
	A/ R Sikaflex-241/-291 <u>M11294157</u>								
	Sikaflex expiry date: <u>14/11</u>								
	3- INSTALL WEARPLATES AS PER DWG								
270 *270* QC	QC5- Inspect part completeness to step on W/O	0.00							
Quality Control	Memo	0.00							
280 *280* Packaging	Identify as per dwg & Stock Location: <u>W10</u>	0.00	D412-742-043 / B115492	1	1	1	1	1	1
Packaging	Memo	0.00							

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____

Date: _____

Work Order update only

Work Order: _____	DISPOSITION			AGAINST DEPARTMENT/PROCESS					
Part No. _____	Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>				
NCR No. _____	Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>				
	Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>				
	Suspected Unapproved <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>					

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear	General											
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Folio/Program	<input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Pressure/Forced								
<input type="checkbox"/> Centre Not Concentric	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Grain	<input type="checkbox"/> Over/Under tolerance	<input type="checkbox"/> Set-up								
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damage/Defect	<input type="checkbox"/> Hardware	<input type="checkbox"/> Part Incorrect	<input type="checkbox"/> Temperature/Cure								
<input type="checkbox"/> Crimp/Kink/Ripple/Wave	<input type="checkbox"/> Burrs	<input type="checkbox"/> Inspection Incomplete/Unqualified	<input type="checkbox"/> Part Lost/Missing	<input type="checkbox"/> Weld								
<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Instructions Incomplete/Unclear	<input type="checkbox"/> Part Moved	<input type="checkbox"/> Wrong Stock Pulled								
<input type="checkbox"/> Crushing	<input type="checkbox"/> Countersink	<input type="checkbox"/> Misaligned/off center	<input type="checkbox"/> Positioned Wrong	<input type="checkbox"/> Other								
<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Mislabeled	<input type="checkbox"/> Power Loss/Surge									
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Drawing	<input type="checkbox"/> Misread										
<input type="checkbox"/> Marks/Chatter	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Off-set										
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Calibration										
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Fit/Function	<input type="checkbox"/> Out of Sequence										

Work Order ID 114293

114293

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Item ID: D3391-025

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Aft Tube Assembly

Stop

NS2

Start Date: 04/03/2014 Start Qty: 1.00

1

Cust Item ID:

Required Date: 04/03/2014 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

290

QC21- Final Inspection - Work Order Release

0.00

14/9/17

14/9/17 JJ

290

QC

Quality Control

Memo

0.00

14/9/17

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only

Work Order: _____	DISPOSITION			AGAINST DEPARTMENT/PROCESS					
Part No. _____	Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>				
NCR No. _____	Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>				
	Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>				
	Suspected Unapproved <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>					

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear		General									
<input type="checkbox"/>	Bending	<input type="checkbox"/>	Bend	<input type="checkbox"/>	Folio/Program	<input type="checkbox"/>	Outside Dimensions	<input type="checkbox"/>	Pressure/Forced		
<input type="checkbox"/>	Centre Not Concentric	<input type="checkbox"/>	BOM/Route	<input type="checkbox"/>	Grain	<input type="checkbox"/>	Over/Under tolerance	<input type="checkbox"/>	Set-up		
<input type="checkbox"/>	Cracks	<input type="checkbox"/>	Broken/Damage/Defect	<input type="checkbox"/>	Hardware	<input type="checkbox"/>	Part Incorrect	<input type="checkbox"/>	Temperature/Cure		
<input type="checkbox"/>	Crimp/Kink/Ripple/Wave	<input type="checkbox"/>	Burrs	<input type="checkbox"/>	Inspection Incomplete/Unqualified	<input type="checkbox"/>	Part Lost/Missing	<input type="checkbox"/>	Weld		
<input type="checkbox"/>	Cuffs	<input type="checkbox"/>	Contamination	<input type="checkbox"/>	Instructions Incomplete/Unclear	<input type="checkbox"/>	Part Moved	<input type="checkbox"/>	Wrong Stock Pulled		
<input type="checkbox"/>	Crushing	<input type="checkbox"/>	Countersink	<input type="checkbox"/>	Misaligned/off center	<input type="checkbox"/>	Positioned Wrong	<input type="checkbox"/>	Other		
<input type="checkbox"/>	Heat Treat	<input type="checkbox"/>	Cut Too Short	<input type="checkbox"/>	Mislabeled	<input type="checkbox"/>	Power Loss/Surge	<input type="checkbox"/>			
<input type="checkbox"/>	Inspection Strip in Tube	<input type="checkbox"/>	Drawing	<input type="checkbox"/>	Misread	<input type="checkbox"/>		<input type="checkbox"/>			
<input type="checkbox"/>	Marks/Chatter	<input type="checkbox"/>	Drill Holes	<input type="checkbox"/>	Off-set	<input type="checkbox"/>		<input type="checkbox"/>			
<input type="checkbox"/>	Turning Sequence	<input type="checkbox"/>	Finish	<input type="checkbox"/>	Out of Calibration	<input type="checkbox"/>		<input type="checkbox"/>			
<input type="checkbox"/>	Wave/Twist in Tube	<input type="checkbox"/>	Fit/Function	<input type="checkbox"/>	Out of Sequence	<input type="checkbox"/>		<input type="checkbox"/>			

• **Picklist Print**

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Page 1

Work Order ID: 114293

114293
D3391-025

Parent Item: D3391-025

Parent Item Name: Aft Tube Assembly

Start Date: 04/03/2014

Required Date: 04/03/2014

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev B	06-02-07	ECN773 dwg rev. D	EC
IPP Rev:C	06-03-28	Update Manuf. Instructions	JLM
IPP rev D	07.03.20	revF dwg	EC
IPP rev E	07.11.07	rev G dwg ecn 1053p	EC verified by: DD
IPP Rev:F	07-11-13	ECN 1056	DD verified by: EC
IPP Rev:G	08-09-10	revH as per dwg	DD verified by:EC
IPP Rev:H			
11.11.14 AS PER REV.I DD verified by:JLM			

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4095-047		Manufactured	No			260	Each	18.0000	1	1	ll	11/03/13	

D4095-047

Wearpad Assembly

Location	Loc Qty	Loc Code
FP001	18	
102241	2	
<u>108289</u>	16	X1

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4095-049		Manufactured	No			260	Each	13.0000	1	1	ll	11/03/13	

D4095-049

Wearpad Assembly

Location	Loc Qty	Loc Code
FP001	12	
<u>109670</u>	12	X1
FP002	1	
102216	1	

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6014-090		Manufactured	No			100	Each	74.0000	1	1	ll	11/03/13	

D6014-090

ALUMINUM EXTRUSION

Location	Loc Qty	Loc Code
LG003	74	
79742	17	
86063	57	

ll 11/03/13
KC 11/03/07

DQA: _____ Date: _____

Date:



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only

• Picklist Print

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Work Order ID: 114293

114293
D3391-025

Parent Item: D3391-025

Parent Item Name: Aft Tube Assembly

Start Date: 04/03/2014

Required Date: 04/03/2014

Start Qty: 1.00

Required Qty: 1.00

D3670-4-200

Manufactured No

230

Each

337.0000

4

4

**

DC14/04/09

D3670-4-200

Bushing

Location	Loc Qty	Loc Code
FG	10	
87709	10	
LG001	327	
103880	60	
109108	242	
96240	25	

D2646

Manufactured No

270

Each

61.0000

1

1

**

all local 16

D2646

Aft Cap

Location	Loc Qty	Loc Code
FG	4	B119656
85848	2	
90495	2	
FP001	57	
103306	18	
107857	1	
110816	38	

D3672-1

Manufactured No

270

Each

1,176.000

2

2

**

all local 16

D3672-1

Phenolic Washer

Location	Loc Qty	Loc Code
FG	10	
85222	10	B113581
ST060	1166	
103845	4	
112218	500	
93886	450	
99099	212	

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Shop Packet Print

Page 2

DQA: _____ Date: _____

Date:



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date:

Work Order update only

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION		AGAINST DEPARTMENT/PROCESS					
Suspected Unapproved				Rework Scrap Use-as-is	Skid-tube Machining Thermoforming Large Fab	Crosstube Small Fab Finishing Composite	Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier	Engineering Quality Other			
Root Cause		Date	Step	Qty	Description of work order update or non-conformance		Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design											
Doc/Data											
Equip/Tooling											
Handling/Pre											
Material											
Operator											
Offset/Setup											
Process											
Supplier											
Training											
Transport											
Unapproved											
FAULT CATEGORY											
Landing Gear				General							
Bending Centre Not Concentric Cracks Crimp/Kink/Ripple/Wave Cuffs Crushing Heat Treat Inspection Strip in Tube Marks/Chatter Turning Sequence Wave/Twist in Tube				Bend BOM/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short Drawing Drill Holes Finish Fit/Function							
				Folio/Program Grain Hardware Inspection Incomplete/Unqualified Instructions Incomplete/Unclear Misaligned/off center Mislabeled Misread Off-set Out of Calibration Out of Sequence							
				Outside Dimensions Over/Under tolerance Part Incorrect Part Lost/Missing Part Moved Positioned Wrong Power Loss/Surge							
				Pressure/Forced Set-up Temperature/Cure Weld Wrong Stock Pulled							
				Other							

• **Picklist Print**

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Work Order ID: 114293

114293

Parent Item: D3391-025

D3391-025

Parent Item Name: Aft Tube Assembly

Start Date: 04/03/2014

Required Date: 04/03/2014

ALS4-1032-130 AELS4-1032-130 Purchased

No

260

Each

1,176.000

14

14

**

ll wloal 14

Rivnut

AI S4-1032-130

Location

Loc Qty

Loc Code

ST279

1119

M1128649

x 14

M128179
M128211

158
961

st510

57

M126109

57

ALS4-1032-225

AELS8-1032-225 Purchased

No

270

Each

1,050.000

8

8

**

ll wloal 8

Rivnut

AI S4-1032-225

ALS7-1032-225

Location

Loc Qty

Loc Code

FG

30

M1128649

8

M127028

30

AN3C4A

Purchased

No

270

Each

2,109.000

6

6

**

ll wloal 6

Bolt

AN3C4A

Location

Loc Qty

Loc Code

FG

20

M1129520

x 6

122814

20

DQA: _____

Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____

Date: _____

Work Order update only

Work Order: _____	DISPOSITION	AGAINST DEPARTMENT/PROCESS					
Part No. _____	Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>		
NCR No. _____	Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>		
	Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>		
	Suspected Unapproved <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>			

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear	General				
	<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Folio/Program	<input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Pressure/Forced
	<input type="checkbox"/> Centre Not Concentric	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Grain	<input type="checkbox"/> Over/Under tolerance	<input type="checkbox"/> Set-up
	<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damage/Defect	<input type="checkbox"/> Hardware	<input type="checkbox"/> Part Incorrect	<input type="checkbox"/> Temperature/Cure
	<input type="checkbox"/> Crimp/Kink/Ripple/Wave	<input type="checkbox"/> Burrs	<input type="checkbox"/> Inspection Incomplete/Unqualified	<input type="checkbox"/> Part Lost/Missing	<input type="checkbox"/> Weld
	<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Instructions Incomplete/Unclear	<input type="checkbox"/> Part Moved	<input type="checkbox"/> Wrong Stock Pulled
	<input type="checkbox"/> Crushing	<input type="checkbox"/> Countersink	<input type="checkbox"/> Misaligned/off center	<input type="checkbox"/> Positioned Wrong	<input type="checkbox"/> Other
	<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Mislabeled	<input type="checkbox"/> Power Loss/Surge	
	<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Drawing	<input type="checkbox"/> Misread		
	<input type="checkbox"/> Marks/Chatter	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Off-set		
	<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Calibration		
	<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Fit/Function	<input type="checkbox"/> Out of Sequence		

• **Picklist Print**

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Work Order ID: 114293

114293

Parent Item: D3391-025

D3391-025

Parent Item Name: Aft Tube Assembly

Start Date: 04/03/2014

Required Date: 04/03/2014

Start Qty: 1.00

Required Qty: 1.00

AN3C5A

Purchased

No

270

Each

1,125.000

4

4

**

AN3C5A

Bolt

All w/loc 14

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FG	5	11129913
122800	5	<i>x 4</i>
ST350	1120	
M128057	1120	

NAS1149C0332R

Purchased

No

270

Each

7,778.000

10

10

**

NAS1149C0332R

WASHER

All w/loc 16

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
GA	1125	
125654	1125	
st510	6653	
m126319	89	
m127306	2500	
<u>m127410</u>	3000	
m127831	1064	<i>x 10</i>

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only

Work Order: _____	DISPOSITION	AGAINST DEPARTMENT/PROCESS							
Part No. _____	Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>				
NCR No. _____	Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>				
	Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>				
	Suspected Unapproved <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>					

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY									
Landing Gear	General								
Bending	Bend <input type="checkbox"/>	Folio/Program <input type="checkbox"/>	Outside Dimensions <input type="checkbox"/>	Pressure/Forced <input type="checkbox"/>					
Centre Not Concentric	BOM/Route <input type="checkbox"/>	Grain <input type="checkbox"/>	Over/Under tolerance <input type="checkbox"/>	Set-up <input type="checkbox"/>					
Cracks	Broken/Damage/Defect <input type="checkbox"/>	Hardware <input type="checkbox"/>	Part Incorrect <input type="checkbox"/>	Temperature/Cure <input type="checkbox"/>					
Crimp/Kink/Ripple/Wave	Burrs <input type="checkbox"/>	Inspection Incomplete/Unqualified <input type="checkbox"/>	Part Lost/Missing <input type="checkbox"/>	Weld <input type="checkbox"/>					
Cuffs	Contamination <input type="checkbox"/>	Instructions Incomplete/Unclear <input type="checkbox"/>	Part Moved <input type="checkbox"/>	Wrong Stock Pulled <input type="checkbox"/>					
Crushing	Countersink <input type="checkbox"/>	Misaligned/off center <input type="checkbox"/>	Positioned Wrong <input type="checkbox"/>	Other <input type="checkbox"/>					
Heat Treat	Cut Too Short <input type="checkbox"/>	Mislabeled <input type="checkbox"/>	Power Loss/Surge <input type="checkbox"/>						
Inspection Strip in Tube	Drawing <input type="checkbox"/>	Misread <input type="checkbox"/>							
Marks/Chatter	Drill Holes <input type="checkbox"/>	Off-set <input type="checkbox"/>							
Turning Sequence	Finish <input type="checkbox"/>	Out of Calibration <input type="checkbox"/>							
Wave/Twist in Tube	Fit/Function <input type="checkbox"/>	Out of Sequence <input type="checkbox"/>							

DART AEROSPACE LTD		Work Order:	114293
Description: Float Skidtube (412)		Part Number:	D3391-3
Inspection Dwg: D3391 Rev: 1		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Lathe Section						
14.000	+/-0.010	14.000	—		tape	L6-25
3.500	+/-0.010	3.499	—		vern	CNC-08
Ø3.200	+/-0.010	3.201	—			
Ø3.750	+/-0.010	3.750	—			
30° x 0.060 chamfer	+/-0.010	30° X .060	✓	✓		
88.93	+/-0.030	88.93	✓		tape	L6-25

Measured by: *DKM*

Date: 14/03/08

Audited by: *SM*

Date: 14/03/08

HAAS Section						
1.526	+0.000/-0.030	1.510	—		Vern	M6-06
7.500	+/-0.010	7.500	—		"	
27.750	+/-0.010	27.750	—		M-tape	M6-08
31.750	+/-0.010	31.750	—		"	
35.250	+/-0.010	35.250	—		"	
3.300	+/-0.010	3.293	—		Vern	M6-06
0.200	+/-0.010	.200	—			
3.520	+/-0.010	3.514	—			
0.687	+0.010/-0.000	.687	—			
R0.062	+/-0.010	R0.062	—			
Ø0.484	+0.005/-0.001	Ø.487	—			

Measured by: *DKR*

Date: 14/03/16

Audited by: *H-A*

DAS
08

Date: 14/03/16

Rev	Date	Change	9-89	Revised by	Approved
A	06.04.24	New Issue	P/O D3391-015/-025	KJ/JLM	
B	06.06.19	Dwg revision update		KJ/JLM	
C	07.04.20	Ø0.208 dimension removed		KJ/JLM	
D	07.09.06	0.400 dimension removed		KJ/JLM	
E	07.11.23	Dwg Rev. updated		KJ/EC/DD	
F	09.04.27	Dimensions updated per Rev H and NCR09-028		KJ/JLM	
G	09.11.16	Dimension 0.200 removed		KJ	
H	11.06.21	Dimension 44.995 removed		KJ	
I	12.05.15	Dwg Rev updated		KJ	
J	12.05.23	Dimension updated		KJ	
K	12.10.15	88.93 dimension removed		KJ	
L	12.11.28	88.93 dimension added		KJ	<i>JK</i> <i>AM</i>

DQA:

Date:



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date:

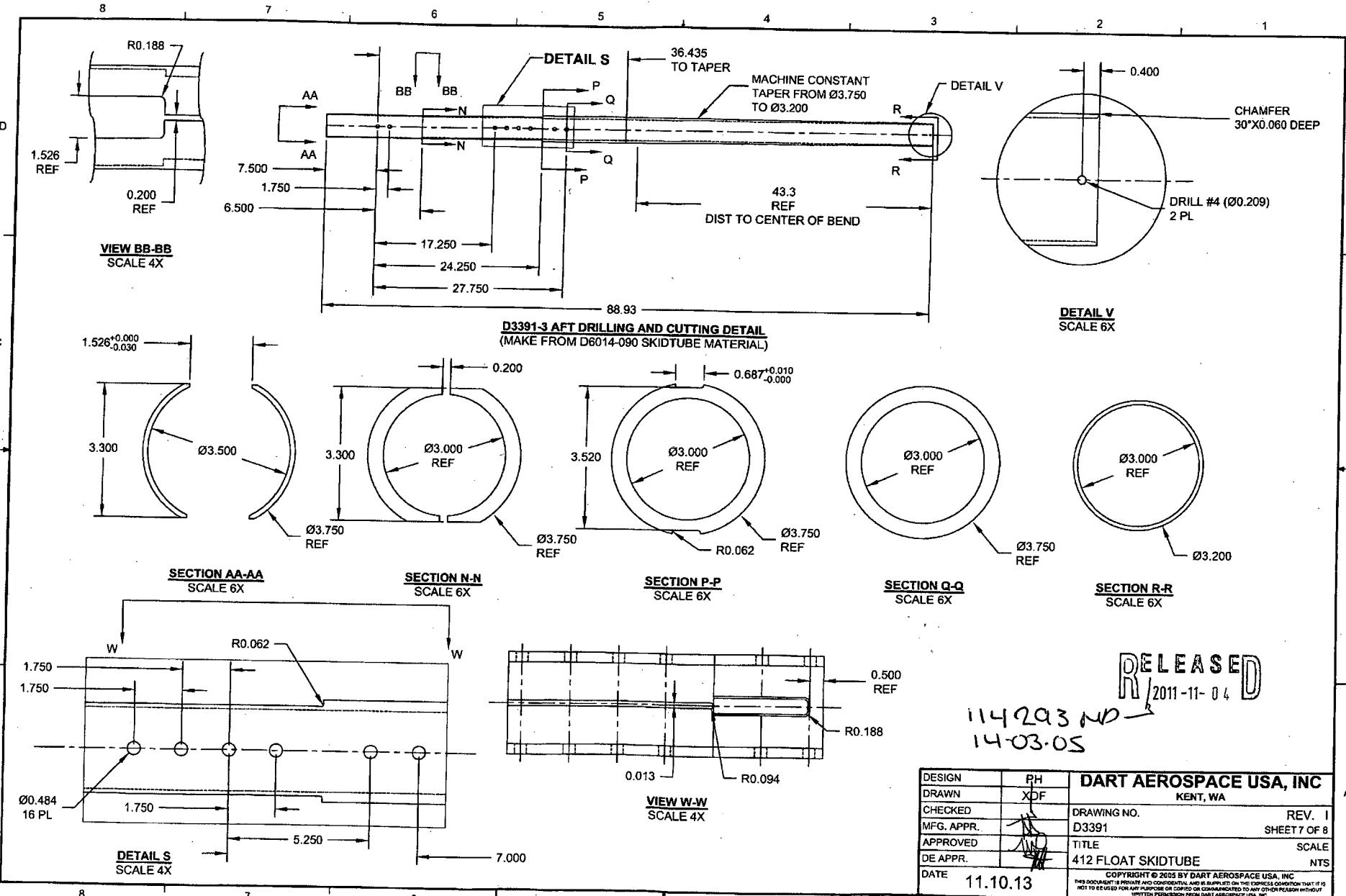
Work Order update only

Work Order: _____	DISPOSITION <input type="checkbox"/> Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved	AGAINST DEPARTMENT/PROCESS <input type="checkbox"/> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> Water Jet <input type="checkbox"/> Prod. Eng. Coor. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other
Part No. _____		
NCR No. _____		

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Pressure/Forced Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other



DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____

Date: _____

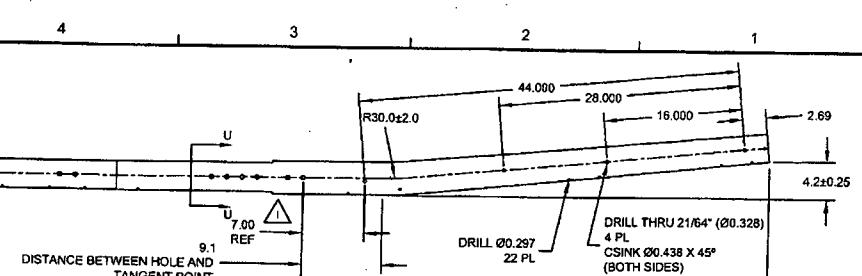
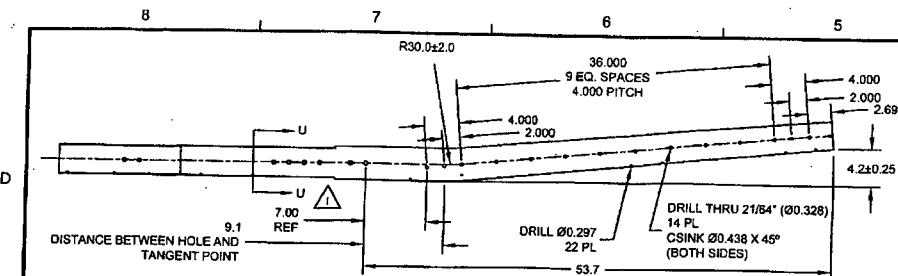
Work Order update only

Work Order: _____	DISPOSITION			AGAINST DEPARTMENT/PROCESS					
Part No. _____	Rework <input type="checkbox"/>	Scrap <input type="checkbox"/>	Use-as-is <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>
NCR No. _____	Suspected <input type="checkbox"/>	Unapproved <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Supplier <input type="checkbox"/>

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

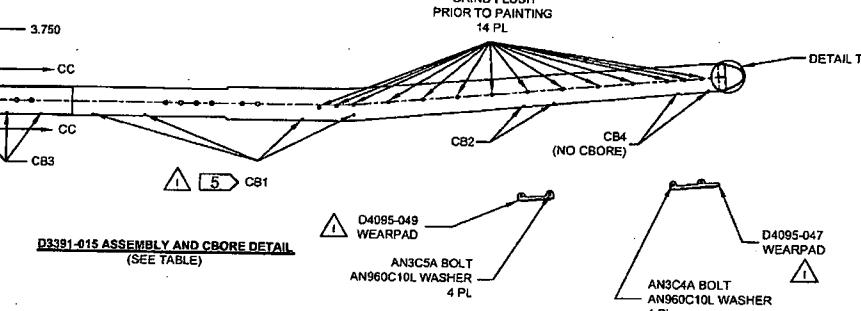
FAULT CATEGORY

Landing Gear	Bending Centre Not Concentric Cracks Crimp/Kink/Ripple/Wave Cuffs Crushing Heat Treat Inspection Strip in Tube Marks/Chatter Turning Sequence Wave/Twist in Tube	General Bend BOM/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short Drawing Drill Holes Finish Fit/Function	Folio/Program Grain Hardware Inspection Incomplete/Unqualified Instructions Incomplete/Unclear Misaligned/off center Mislabeled Misread Off-set Out of Calibration Out of Sequence	Outside Dimensions Over/Under tolerance Part Incorrect Part Lost/Missing Part Moved Positioned Wrong Power Loss/Surge	Pressure/Forced Set-up Temperature/Cure Weld Wrong Stock Pulled Other
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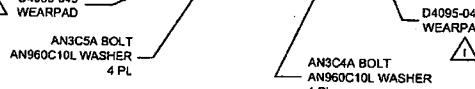


**D3391-015 BENDING AND DRILLING DETAIL
(SEE CBORE DETAIL BELOW)**

INSTALL D3670-4200 SPACER
SEAL WITH MAGNOBOND 6398
GRIND FLUSH
PRIOR TO PAINTING
14 PL



**D3391-015 ASSEMBLY AND CBORE DETAIL
(SEE TABLE)**

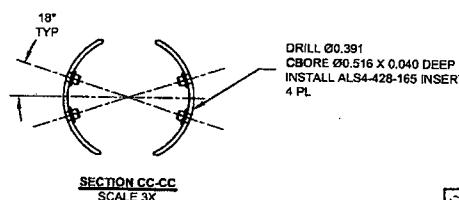
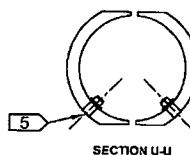


D3391-015/-025 AFT TUBE ASSEMBLY PARTS LIST

QTY - 015	QTY - 025	PART NUMBER	DESCRIPTION
X	D3391-015		AFT TUBE ASSEMBLY
X	D3391-025		AFT TUBE ASSEMBLY
1	1	D2646	AFT CAP
14	4	D3670-4200	SPACER
2	2	D3672-1	WASHER
1	1	D4095-049	WEARPAD
1	1	D4095-047	WEARPAD
1	1	D6014-090	AFT TUBE
14	14	AELS-1032-130	INSERT
8	8	AELS-1032-225	INSERT
4	4	ALS4-428-165	INSERT
6	6	AN3C4A	BOLT
4	4	AN3C5A	BOLT
10	10	AN960C10L	WASHER

CBORE HOLES MARKED CB1-CB4 AS FOLLOWS AND
INSTALL AELS-1032-XXX AFTER FINISH AS NOTED

HOLES MARKED	QTY D3391-015	QTY D3391-025	CBORE	P/N
CB1	8	8	Ø0.430 X 0.170	AELS-1032-225
CB2	4	4	Ø0.430 X 0.170	AELS-1032-130
CB3	6	6	Ø0.430 X 0.040	AELS-1032-130
CB4	4	4	NONE	AELS-1032-130



RELEASED
2011-11-04

DESIGN	PH	DART AEROSPACE USA, INC
DRAWN	XDF	KENT, WA
CHECKED		DRAWING NO.
MFG. APPR.		REV. I
APPROVED		D3391
DE APPR.		SHEET 8 OF 8
DATE	11.10.13	SCA
		412 FLOAT SKIDTUBE
		NTS

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DQA:

Date:



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date:

Work Order update only

Work Order: _____
 Part No. _____
 NCR No. _____

DISPOSITION

Rework
 Scrap
 Use-as-is
 Suspected Unapproved

AGAINST DEPARTMENT/PROCESS

Skid-tube
 Machining
 Thermoforming
 Large Fab

Crosstube
 Small Fab
 Finishing
 Composite

Water Jet
 Prod. Eng. Coor.
 Rec/Store/Packaging
 Supplier

Engineering
 Quality
 Other

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY**Landing Gear**

Bending
 Centre Not Concentric
 Cracks
 Crimp/Kink/Ripple/Wave
 Cuffs
 Crushing
 Heat Treat
 Inspection Strip in Tube
 Marks/Chatter
 Turning Sequence
 Wave/Twist in Tube

General

Bend
 BOM/Route
 Broken/Damage/Defect
 Burrs
 Contamination
 Countersink
 Cut Too Short
 Drawing
 Drill Holes
 Finish
 Fit/Function

Folio/Program

Grain

Hardware

Inspection Incomplete/Unqualified

Instructions Incomplete/Unclear

Misaligned/off center

Mislabeled

Misread

Off-set

Out of Calibration

Out of Sequence

Outside Dimensions

Over/Under tolerance

Part Incorrect

Part Lost/Missing

Part Moved

Positioned Wrong

Power Loss/Surge

Pressure/Forced

Set-up

Temperature/Cure

Weld

Wrong Stock Pulled

Other